

Work Order ID 61693

Tuesday, August 31, 2010 11:51:02 AM



Page 1

Item ID: D3637-041

Revision ID:

Item Name: Bracket Assembly

Start Date: 8/31/2010 Start Qty: 8.00

Required Date: 9/7/2010 Req'd Qty: 8.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date: 10-8-81

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3637

Rev B

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3637 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

304 . 080

10-9-8

(9)

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

10-9-8

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

S10/09/02

(X9)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 2

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Stop



Cust Item ID:

Customer:



Approvals: Process Plan:

QC:

Date:

Tooling:

Date:

Run Start



Stop



Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Brake NC

NC BRAKE

0.00

Memo

0.00

Form as per Dwg D3637

S/S 10/09/29

(9)

140



Small Fab

Small Fab

0.00

Memo

0.00

1- drill holes as per dwg using DT8979 □ 2-C'Sink as per Dwg D3637 □ 3-
Install Nut plate as per Dwg D3637

E/S 10/09/29 (9)

150



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S 10/10/01

(XS)

Quality Control

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Tuesday, August 31, 2010 11:51:02 AM



Page 3

Item ID: D3637-041

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Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:



Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Packaging

Identify as per dwg & Stock Location: 244A

0.00

Memo

0.00

Packaging

10/10/04 sf (90)

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/10/04 JF

ME
10-10-04

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NOTE: Date & initial all entries

Picklist Print

Tuesday, August 31, 2010 11:51:06 AM

Page 1

Work Order ID: 61693

Parent Item: D3637-041

Parent Item Name: Bracket Assembly



Start Date: 8/31/2010

Required Date: 9/7/2010

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC
IPP Rev:B change to REV.B as per dwg 08-02-11 DD verified by:ec

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|-----------------------------------|------------------------|---------------|-----------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| MS20426AD3-3 Rivet | | Purchased | No | | | 100 | Each | 5,053.000 | 2 | 16 | | | |
| | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | | |
| | | | ST316 | | 5053 | | | | | | | | |
| | | | 19099 | | 4774 | | | | | | | | |
| | | | 7681 | | 279 | | | | | | | | |
| M304S14GA 304SS sheet .080 | | Purchased | No | | | 140 | sf | 106.8108 | 0.09 | 0.757895 | | | |
| | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | | |
| | | | MAT20 | | 106.8108 | | | | | | | | |
| | | | 113295 | | 106.8108 | | | | | | | | |
| MS21059L4 Nutplate | | Purchased | No | | | 140 | Each | 49.0000 | 1 | | | | |
| | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | | |
| | | | ST301 | | 30 | | | | | | | | |
| | | | 114718 | | 30 | | | | | | | | |
| | | | ST302 | | 19 | | | | | | | | |
| | | | 112243 | | 19 | | | | | | | | |

Handwritten: 8/30/09/29

Handwritten: 1810-9-8

Handwritten: 13295, 8/30/09/29

Handwritten: 49

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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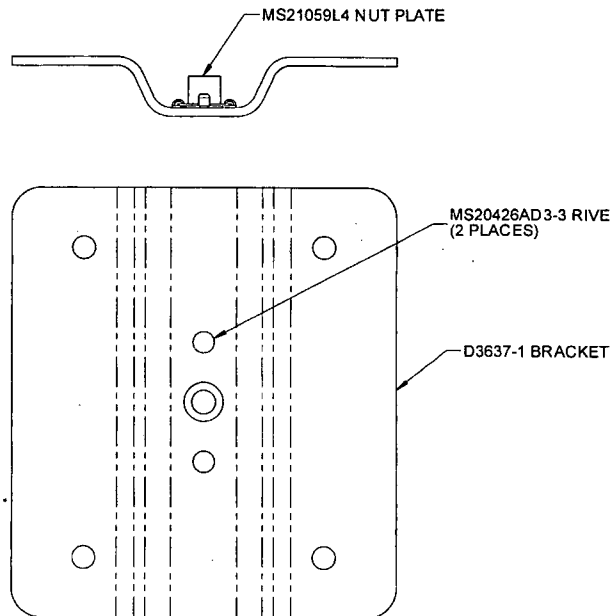
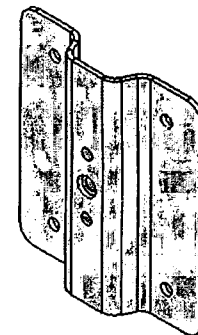
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NOTE: Date & initial all entries

STOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 61493
 10-8-31



D3637-041 BRACKET ASSEMBLY
 (WAS GENEVA P/N G10602-1)

D3637-041 PARTS:

| QTY | P/N | DESCRIPTION |
|-----|--------------|------------------|
| X | D3637-041 | BRACKET ASSEMBLY |
| 1 | D3637-1 | BRACKET |
| 1 | MS21059L4 | NUTPLATE |
| 2 | MS20426AD3-3 | RIVET |

D3637-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: N/A
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.27 lbs

| | | | |
|------------|---|---|--------------|
| B | FOR D3637-1, 1 15 WAS 1 30 & "REF" REMOVED FROM ANGLE | LE | 07.12.18 |
| A | NEW ISSUE; REPLACES G10608, G10602 & G10609 | LE | 07.07.27 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | TS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | LE | | |
| CHECKED | AF | DRAWING NO. | REV. B |
| MFG. APPR. | EP | D3637 | SHEET 1 OF 3 |
| APPROVED | 10 | TITLE | SCALE |
| DE APPR. | 10 | BRACKET | 1:1 |
| DATE | 07.12.18 | COPYRIGHT © 2007 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

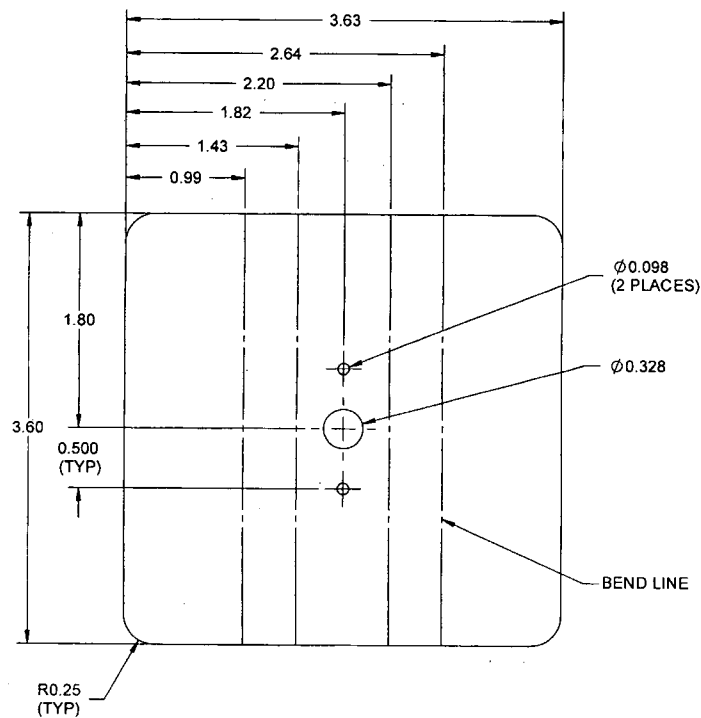
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|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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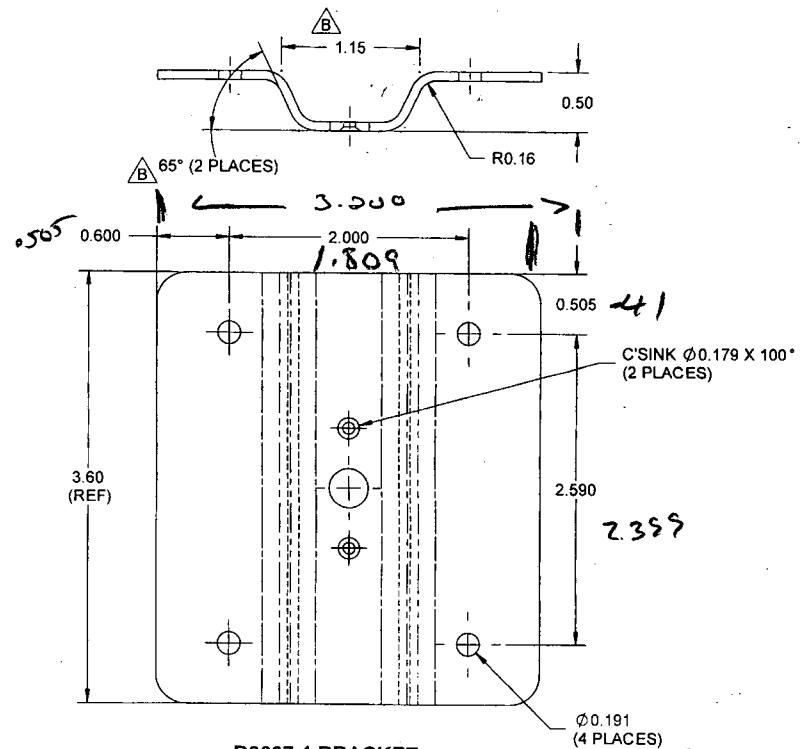
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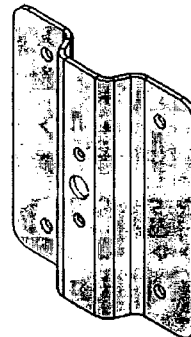
NOTE: Date & initial all entries



D3637-1F FLAT PATTERN



**D3637-1 BRACKET
(WAS GENEVA P/N G10608-1)**



D3637-1 NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 14 GAUGE PER MIL-S-5059 (REF DART SPEC M304S14GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.26 lbs

| | | | |
|--|----------|--|--------------|
| DESIGN | TS | DART AEROSPACE LTD | |
| DRAWN | LE | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | AL | DRAWING NO. | REV. B |
| MFG. APPR. | LE | D3637 | SHEET 2 OF 3 |
| APPROVED | JA | TITLE | SCALE |
| DE APPR. | JA | BRACKET | 1:1 |
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RELEASED
08-02-05

| W/O: | | WORK ORDER CHANGES | | | | | |
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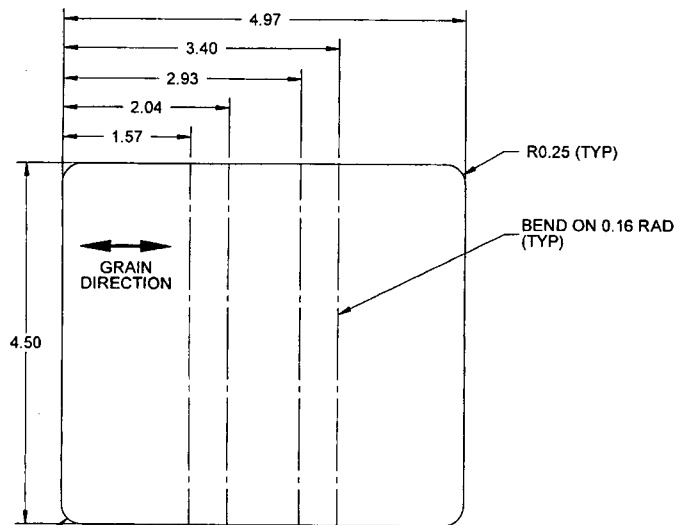
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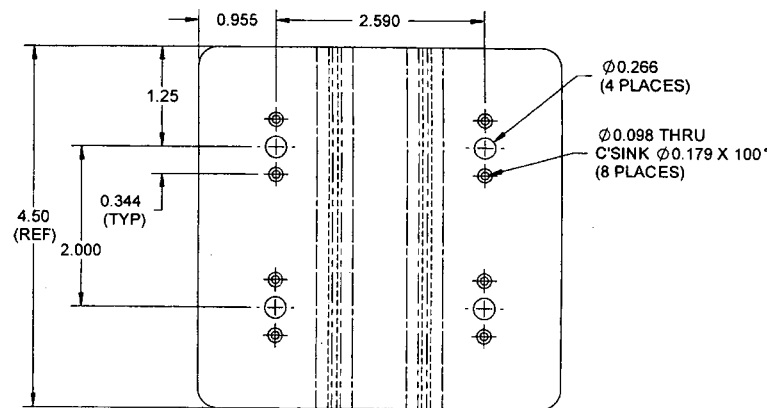
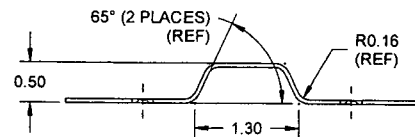
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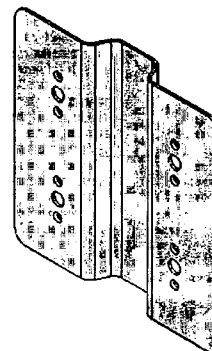
W/O 61693



D3637-3F FLAT PATTERN



**D3637-3 BRACKET
(WAS GENEVA P/N G10609-1)**



D3637-3 NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-3" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.32 lbs

| | | | |
|---|----------|--|--------------|
| DESIGN | TS | DART AEROSPACE LTD | |
| DRAWN | LE | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | PE | DRAWING NO. | REV. B |
| MFG. APPR. | CD | D3637 | SHEET 3 OF 3 |
| APPROVED | IN | TITLE | SCALE |
| DE APPR. | | BRACKET | 2:3 |
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